

Work Order ID 87040

July-10-12 11:56:50 AM

\*87040\*

Page 1

Item ID: D119-646-213

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Float Skidtube w/ Training Wearplates, LH

Stop

\*NS2\*

Start Date: 7/10/12 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D119-646	B

100

\*100\*

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D119-646-213  
CHG 001

110

\*110\*

Packaging

Packaging

Pick Kit

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 87040**

July-10-12 11:56:50 AM

**\*87040\***

Page 2

Item ID: D119-646-213

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Float Skidtube w/ Training Wearplates, LH

Stop

**\*NS2\***Start Date: 7/10/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D119-642-213

Location: 73

PPP rev: \_\_\_\_\_

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Quality Control

Memo

0.00

MLJ 12/08/17

MF

12-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Picklist Print

July-10-12 11:56:49 AM

Page 1

**Work Order ID:** 87040

Parent Item: D119-646-213

**Parent Item Name:** Float Skidtube w/ Training Wearplates, LH

**Start Date:** 7/10/12

**Required Date:** 8/17/12

**Comments:** IPP RevA: New issue DD verified by:EC

**Start Qty:** 1.00

**Required Qty:** 1.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							/

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July-10-12 11:56:49 AM

Page 2

Work Order ID: 87040

Parent Item: D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 7/10/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

AN3G50A

Bolt

Purchased No 110 Each 50.0000

8

8

JB

AN4G6A

Bolt

Purchased No 110 Each 423.0000

13

18

JB

MS21250-05-006

BOLT

Purchased No 110 Each 20.0000

8

8

JB

AN960C10L

washer

NAS1149C0332R Purchased No 110 Each 21.0000

17

17

9X M122063

JB

87 M121509

AN960C416L

WASHER

AN960G516L

WASHER

Purchased No 110 Each 0.0000

30

30

24 X 117271

JB

6 X 121255

JB

8

8

19436

JB

12/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July-10-12 11:56:49 AM

Page 3

Work Order ID: 87040

Parent Item: D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 7/10/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Nut

Purchased No

110 Each

1,094.0000

8

8

✓ JB

K

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	72	
103691	72	
ST301	1022	
118077	2	
118614	12	
118686	30	
119758	20	
121255	101	121255
121708	857	

MS21043-4

Nut

Purchased No

110 Each

1,779.0000

13

13

✓ JB

K

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	40	
104603	40	
ST301	739	
119546	4	
121162	295	
121652	440	
ST318	1000	
122141	1000	

D2512

Set Screw

Manufactured No

110 Each

621.0000

12

12

✓ JB

12/07/10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	50	
29962	50	
ST017	571	
81871	71	
83559	250	
84433	250	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July-10-12 11:56:50 AM

Page 4

Work Order ID: 87040

Parent Item: D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 7/10/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D3672-7  
Phenolic Washer

Manufactured No 110 Each 712.0000

24

24

✓ JB

Location	Loc Qty	Loc Code
ST060	712	
73488	16	
76279	196	76279
81872	500	

D3672-3  
Phenolic Washer

Manufactured No 110 Each 1,311.0000

30

30

24 83238 30

✓ JB

Location	Loc Qty	Loc Code
ST060	1311	
84361	311	67 84361
84432	500	
86517	500	

D3407-041  
Tow Ring

Manufactured No 110 Each 2.0000

0

1

✓ JB

D3417-5  
Washer

Manufactured No 110 Each 133.0000

0

1

82068

82024

12/07/10

Location	Loc Qty	Loc Code
ST042	133	
78842	4	
83318	48	
84943	40	
85466	41	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July-10-12 11:56:50 AM

Page 5

Work Order ID: 87040

Parent Item: D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 7/10/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D3456-4  
Washer

Manufactured No 110 Each 215.0000

0 1 ✓ JB

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	7	
25701	7	
ST044	208	
80252	1	
81876	15	81876
83584	92	
85223	100	

D3417-7  
Washer

Manufactured No 110 Each 36.0000

0 1 ✓ JB

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST042	36	
51645	18	51645
75054	18	

AN960JD416  
Washer

NAS1149D0463J Purchased No 110 Each 29.0000

6 121912 6 ✓ JB 12/07/10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	29	
116289	8	
119097	21	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

## 4.3 Float Skidtubes

Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
	X												D119-646-013	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-014	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-113	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-114	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-213	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-214	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
1	1						X						D119-646-043	REPLACEMENT FLOAT SKIDTUBE WITH WEARPADS
		1	1					X					D119-646-143	REPLACEMENT FLOAT SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-153	WEARPLATE KIT STANDARD SKIDTUBE
										X			D119-646-243	REPLACEMENT FLOAT SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-253	TRAINING WEARPLATES FLOAT SKIDTUBE
1	1	1	1	1	1	1						X	D119-646-311	GROUND HANDLING KIT
1							1						D3905-041	FLOAT SKIDTUBE ASSY. WITH WEARPAD
20								1					D3905-043	FLOAT SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
24									1				D3846-1	GASKET
25									1				D3846-11	GASKET
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-049	AFT WEARPLATE ASSY
29									8				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									42				AN3C5A	BOLT
32									42				AN960C10L	WASHER (OR NAS1149C0332R)
40									1				D3905-045	FLOAT SKIDTUBE ASSY. TRAINING WEARPLATE
44										1			D3849-047	FWD TRAINING WEARPLATE ASSY
45										1			D3849-045	AFT TRAINING WEARPLATE ASSY
46										1			D3846-1	GASKET
47										1			D3846-11	GASKET
48										1			D3847-1	WEARPAD
49										1			D3847-11	WEARPAD
51										16			D3904-1	WASHER
52										8			AN3C46A	BOLT
53										8			MS21043-3	NUT
54										10			AN3C5A	BOLT
55										10			AN960C10L	WASHER (OR NAS1149C0332R)
60	2	2		2		2							D3883-1	SADDLE, OUTSIDE, LH
61	2		2		2								D3883-2	SADDLE, OUTSIDE, RH
62	2	2		2		2							D3884-1	SADDLE, INSIDE, LH
63	2		2		2								D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960CS16L	WASHER (OR NAS1149C0532R)

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Revision: B  
Date: 09.06.29

Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2712	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TOW RING
81	1	1	1	1	1	1							D3417-5	WASHER
82	1	1	1	1	1	1							D3456-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
84	1	1	1	1	1	1							D3417-7	WASHER
90												2	D3886-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN960C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT
100	3	3	3	3									AN3C45A	BOLT
101					(3)	(3)							AN3C50A	BOLT
102	3	3	3	3									AN3C45A	BOLT
103					(3)	(3)							AN3C46A	BOLT
104					(9)	(9)							D3904-1	WASHER
105	6	6	6	6	6	6							AN4C6A	BOLT
106	6	6	6	6	6	6							D3672-3	WASHER
107	6	6	6	6	6	6							AN960C416L	WASHER (OR NAS1149C0432R)
108	6	6	6	6	6	6							AN960JD416	WASHER (OR NAS1149C0463J)
109	12	12	12	12	(3)	(3)							AN960C10L	WASHER (OR NAS1149C0332R)
110	6	6	6	6	(6)	(6)							MS21043-3	NUT

( ) ITEMS IN BRACKETS ARE REF. ONLY AND DO NEED TO BE INCLUDED WITH KIT.  
AS THEY ARE ALREADY INSTALLED ON SKIDTUBE.